

What Is Claimed Is:

1. Process for manufacturing a cooling channel piston which has a cooling channel approximately in the area behind a ring belt, where a piston blank is shaped at least partially in a forging process, characterized in that at least one circumferential shoulder is formed, behind the at least one shoulder a recess is introduced and then the at least one shoulder is reshaped by means of deformation such that the recess is closed by the at least one shoulder to create the cooling channel.

2. Process in accordance with claim 1, wherein the reshaping takes place by forging.

3. Process in accordance with claim 1, wherein the reshaping takes place by swaging.

4. Process in accordance with claim 1, wherein the reshaping takes place by driving through a hollow form.

5. Process in accordance with claim 1, wherein the reshaping takes place by pressure rolling.

6. Process in accordance with one of the preceding claims, wherein the at least one shoulder is rigidly connected to said piston blank or to another shoulder.

7. Process in accordance with claim 6, wherein the contact area is reworked.

8. Process in accordance with one of the preceding claims, wherein the shoulder is furnished with sealing means in the contact area with respect to the piston blank.